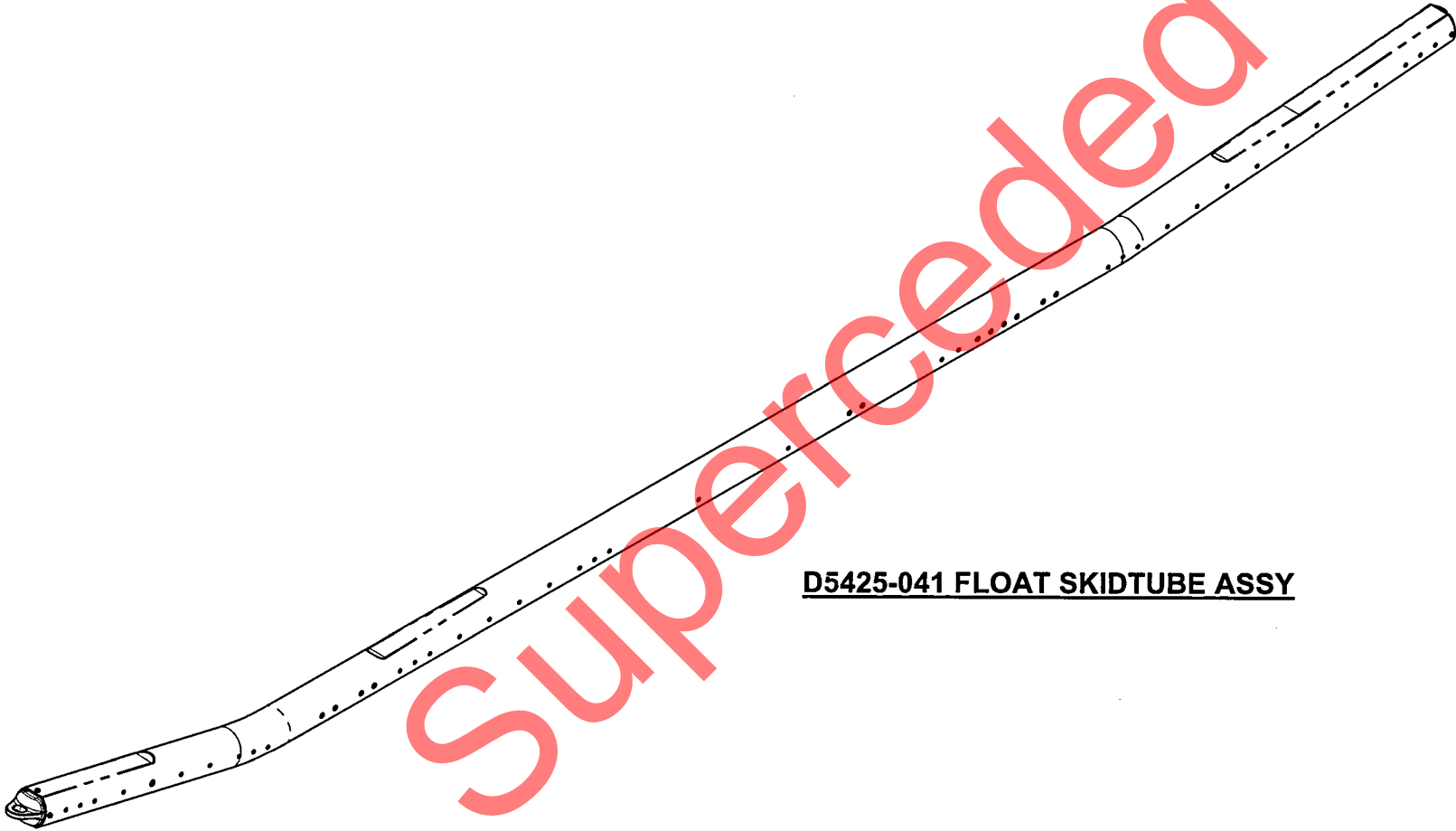


QTY -041	P/N	DESCRIPTION
X	D5425-041	FLOAT SKIDTUBE ASSY
6	D3672-1	WASHER
1	D5425-1	FLOAT SKIDTUBE
1	D5483-041	TOW CAP ASSY
1	D5484-041	AFT CAP ASSY
12	D5512-1	CROSSBOLT SPACER
37	D5518-1	CROSSBOLT SPACER
6	AN3C5A	BOLT
6	NAS1149C0332R	WASHER



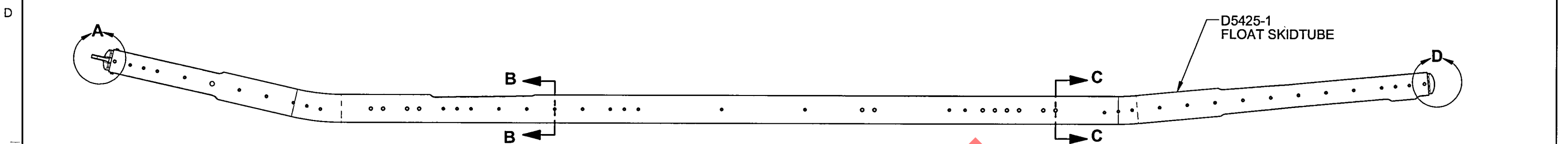
D5425-041 FLOAT SKIDTUBE ASSY

SUPERCEDED

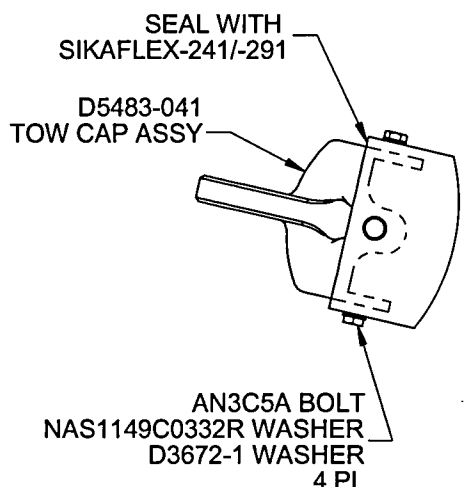
RELEASED
2017-10-31
ECN 17-728

APPROVED
[Signature]

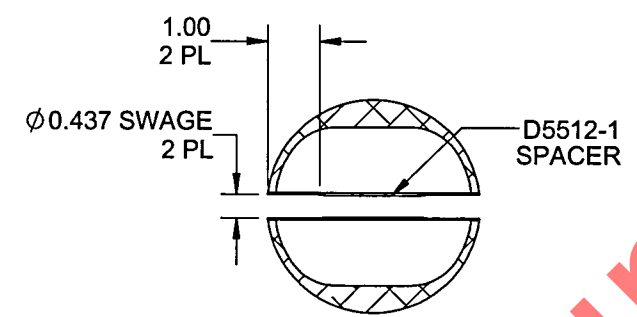
A	NEW ISSUE	NO	17.07.19
REV.	DESCRIPTION		BY DATE
DESIGN	NO	DART AEROSPACE USA, INC. EUGENE, OR	
DRAWN	NO		
CHECKED	AJS	DRAWING NO.	REV. A
MFG. APPR.	DP	D5425	SHEET 1 OF 10
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	412 FLOAT SKIDTUBE	NTS
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D5425-041 FLOAT SKIDTUBE ASSY

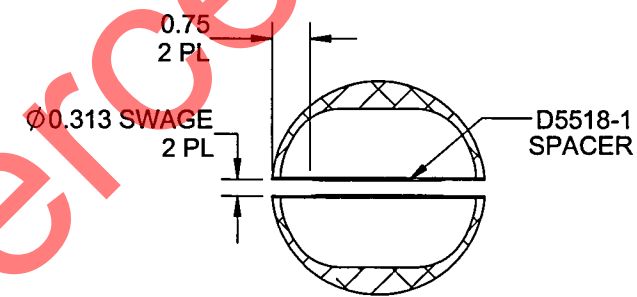


DETAIL A
SCALE 4X



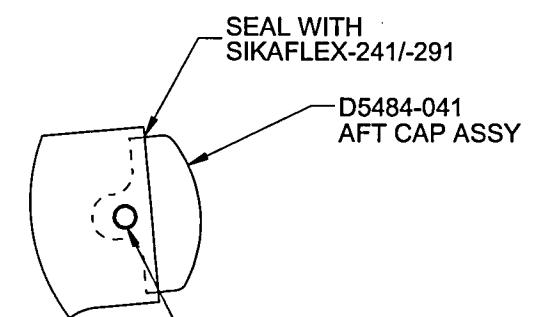
AFTER DRILLING AND BENDING, PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. WET INSTALL D5512-1 SPACER PER QSI 002
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM / GRIND FLUSH PER QSI 002

SECTION C-C
SCALE 4X
12 PL



AFTER DRILLING AND BENDING, PERFORM THE FOLLOWING FOR Ø0.377 HOLES ONLY:
1. INSERT D5518-1 SPACER
2. SWAGE TO Ø0.313 X 0.75 DEEP PER QSI 002
3. TRIM / GRIND FLUSH PER QSI 002

SECTION B-B
SCALE 4X
37 PL



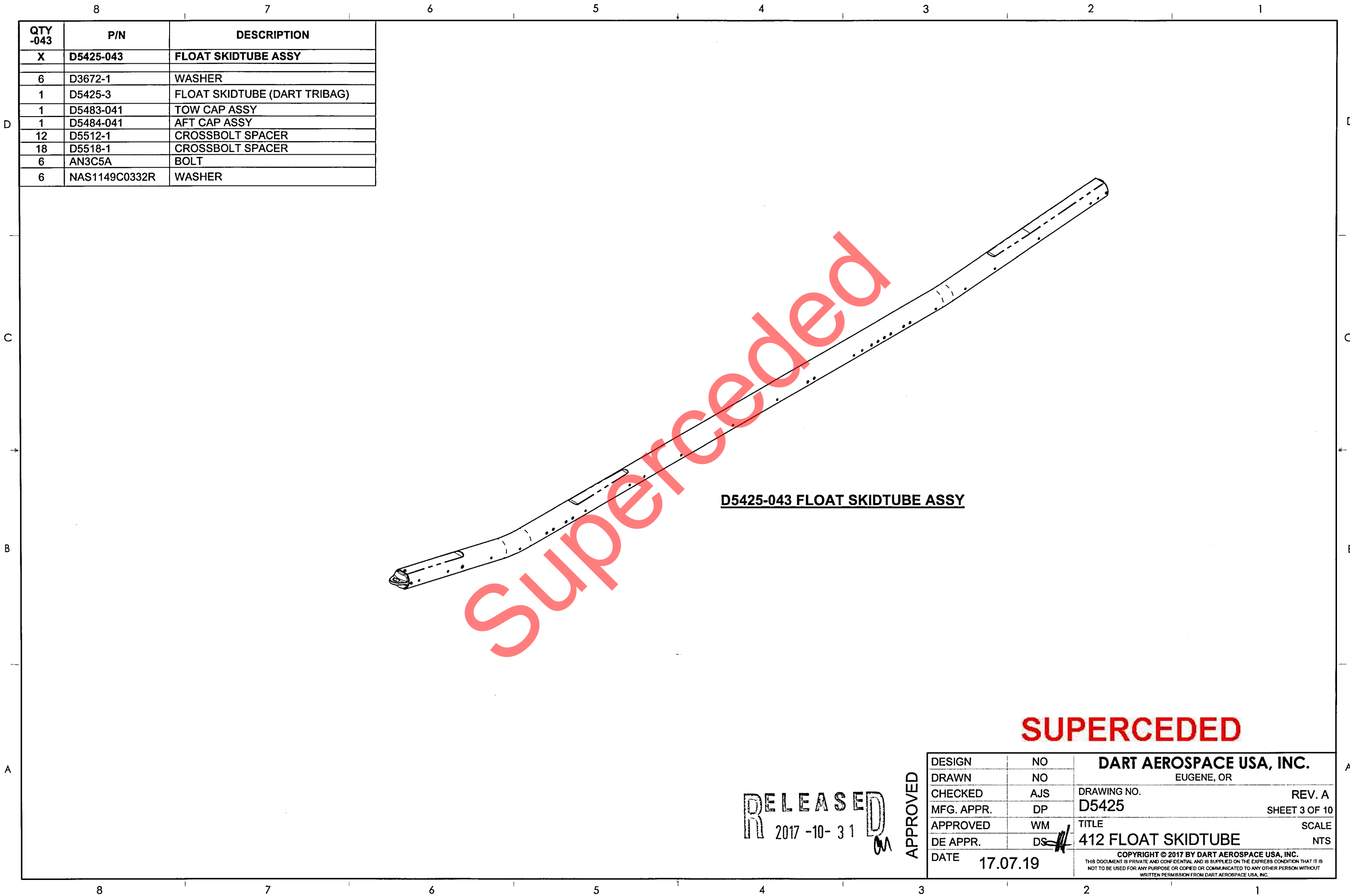
DETAIL D
SCALE 4X

- NOTES:**
1) MATERIAL: N/A
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME PER DART QSI 005 4.2.1.3.3
PAINT PER DART QSI 005 4.2.2.4
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
7) WEIGHT: 54.5lbs
8) COAT ALL EXPOSED FASTENERS WITH LPS "LPS PROCYON"

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2017-10-31
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DESIGN	NO	DART AEROSPACE USA, INC.	
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CHECKED	AJS	DRAWING NO.	REV. A
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QTY -043	P/N	DESCRIPTION
X	D5425-043	FLOAT SKIDTUBE ASSY
6	D3672-1	WASHER
1	D5425-3	FLOAT SKIDTUBE (DART TRIBAG)
1	D5483-041	TOW CAP ASSY
1	D5484-041	AFT CAP ASSY
12	D5512-1	CROSSBOLT SPACER
18	D5518-1	CROSSBOLT SPACER
6	AN3C5A	BOLT
6	NAS1149C0332R	WASHER

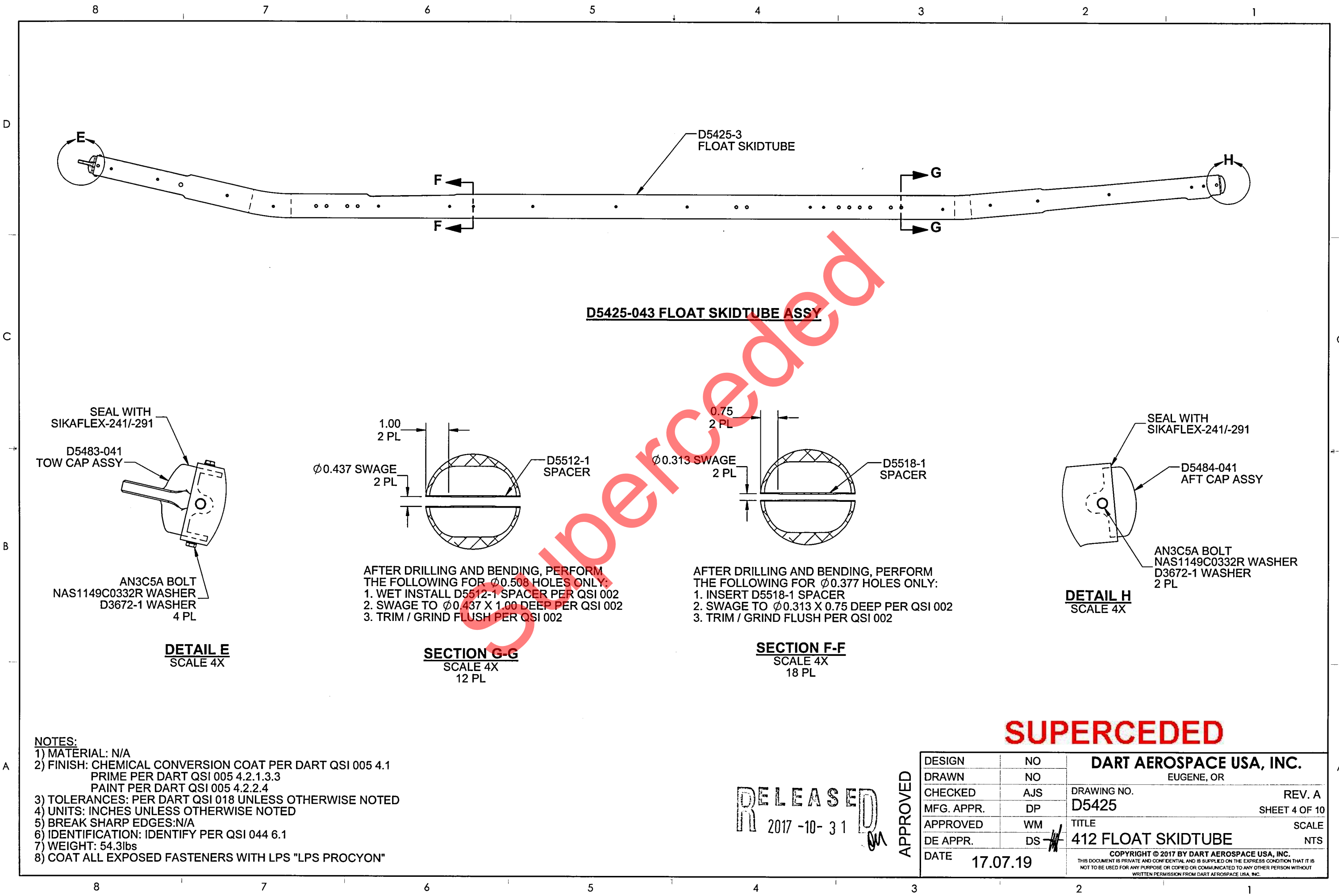
D5425-043 FLOAT SKIDTUBE ASSY

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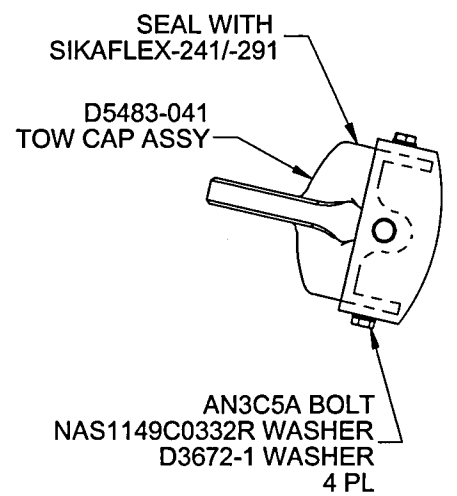
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2017 -10- 3 1

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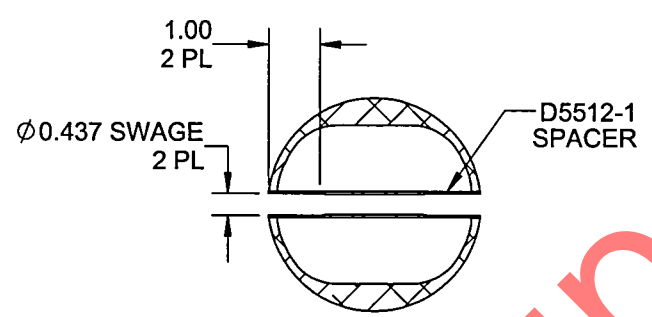
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DRAWN	NO	EUGENE, OR	
CHECKED	AJS	DRAWING NO.	REV. A
MFG. APPR.	DP	D5425	SHEET 3 OF 10
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	412 FLOAT SKIDTUBE	NTS
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D5425-043 FLOAT SKIDTUBE ASSY

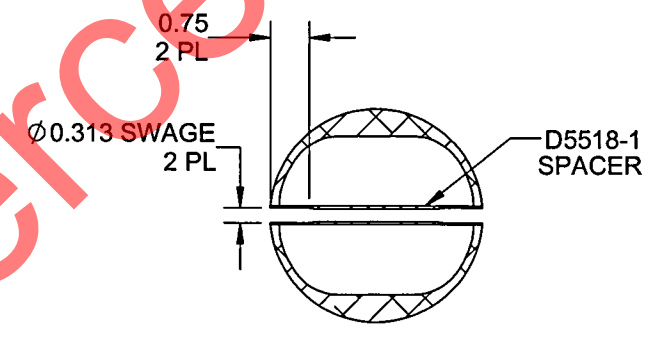


DETAIL E
SCALE 4X



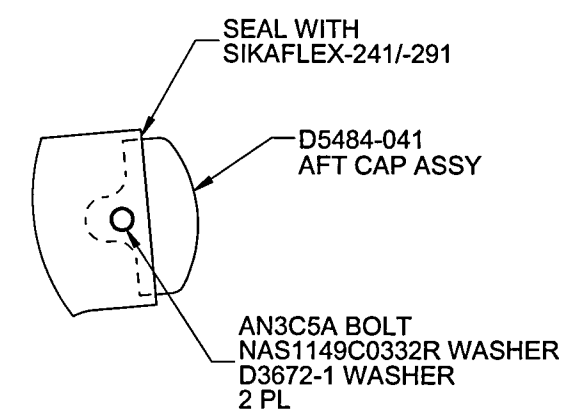
AFTER DRILLING AND BENDING, PERFORM
THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. WET INSTALL D5512-1 SPACER PER QSI 002
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM / GRIND FLUSH PER QSI 002

SECTION G-G
SCALE 4X
12 PL



AFTER DRILLING AND BENDING, PERFORM
THE FOLLOWING FOR Ø0.377 HOLES ONLY:
1. INSERT D5518-1 SPACER
2. SWAGE TO Ø0.313 X 0.75 DEEP PER QSI 002
3. TRIM / GRIND FLUSH PER QSI 002

SECTION F-F
SCALE 4X
18 PL



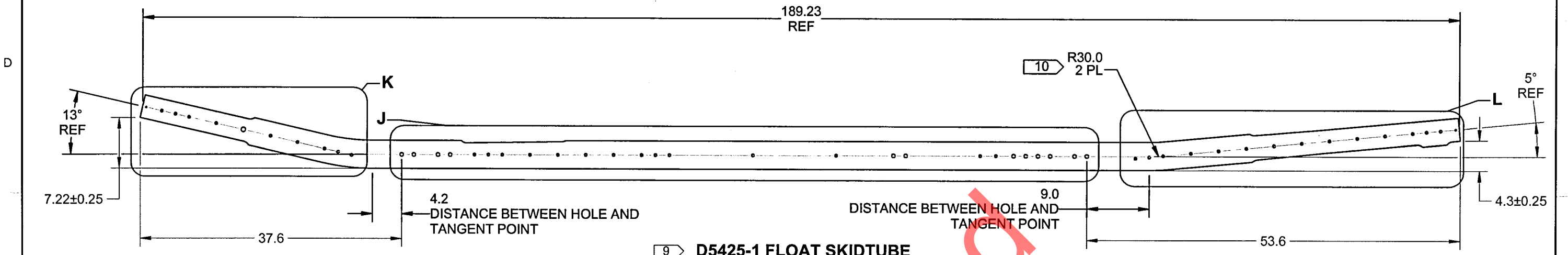
DETAIL H
SCALE 4X

- NOTES:**
1) MATERIAL: N/A
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME PER DART QSI 005 4.2.1.3.3
PAINT PER DART QSI 005 4.2.2.4
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
7) WEIGHT: 54.3lbs
8) COAT ALL EXPOSED FASTENERS WITH LPS "LPS PROCYON"

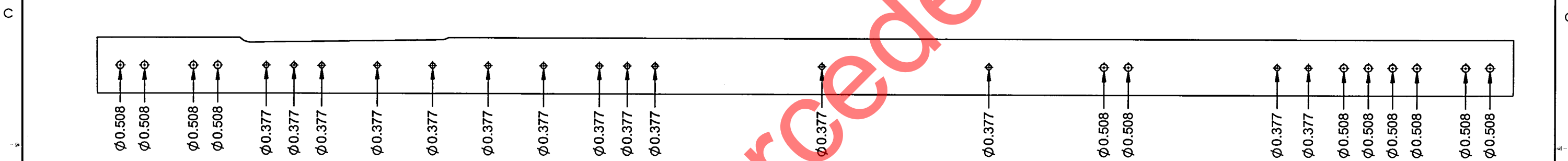
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2017 -10- 31

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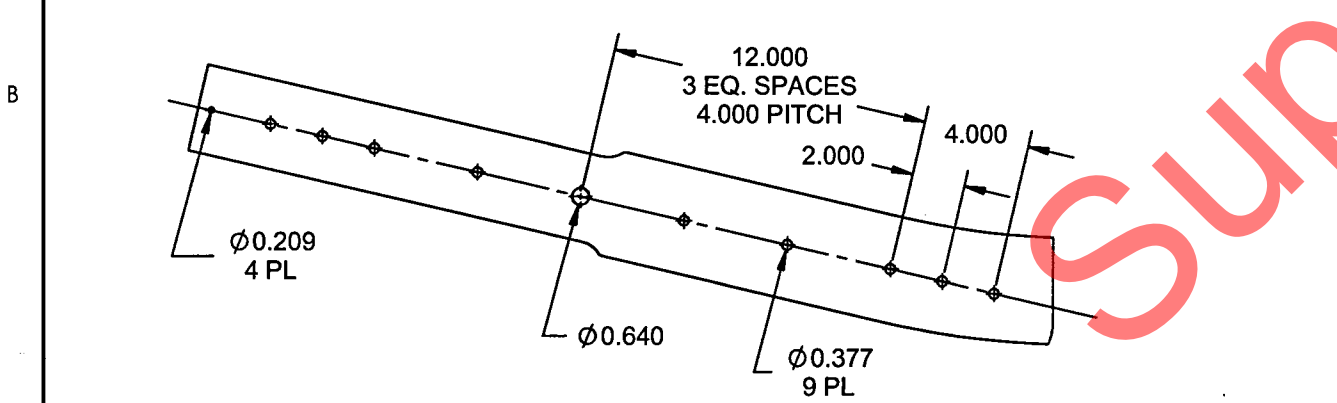
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DRAWN	NO	EUGENE, OR	
CHECKED	AJS	DRAWING NO.	REV. A
MFG. APPR.	DP	D5425	SHEET 4 OF 10
APPROVED	WM	TITLE	SCALE
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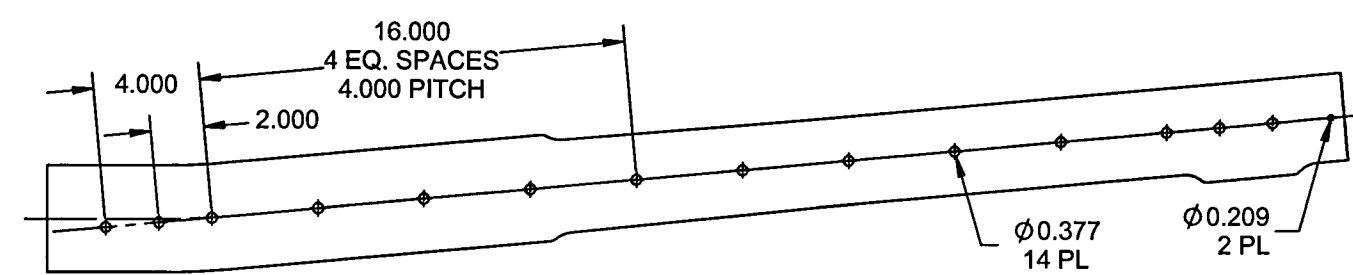
9 **D5425-1 FLOAT SKIDTUBE**



8 **DETAIL J**
SCALE 2X



8 **DETAIL K**
SCALE 2X



8 **DETAIL L**
SCALE 2X

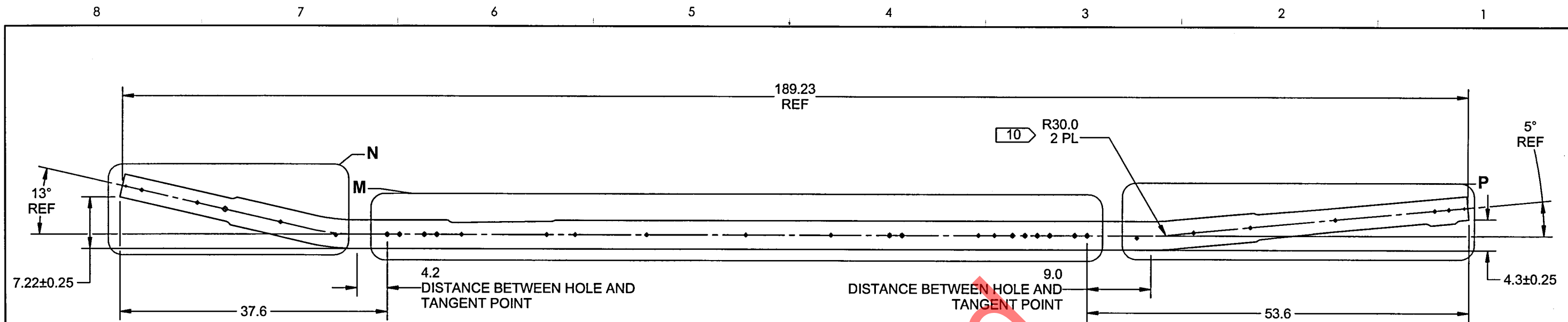
- NOTES:**
- 1) MATERIAL: MAKE FROM D5425-1DRILL
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 52.57 lbs
 - 8) ALL CENTERLINE HOLES THRU, BOTH SIDES AND ALIGNED WITHIN 0.010
 - 9) MAXIMUM TWIST ALLOWANCE 3° BETWEEN FWD AND AFT BEND, 3° FROM EXTRUSION CENTERLINE AT ANY POINT
 - 10) MAXIMUM 5% CRUSHING PER QSI 038 7.1

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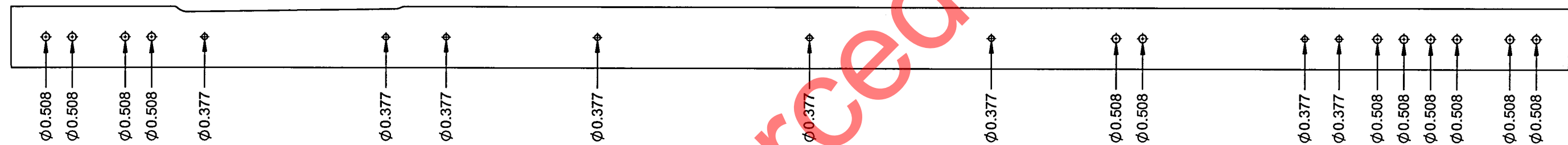
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MFG. APPR.	DP	D5425	SHEET 5 OF 10
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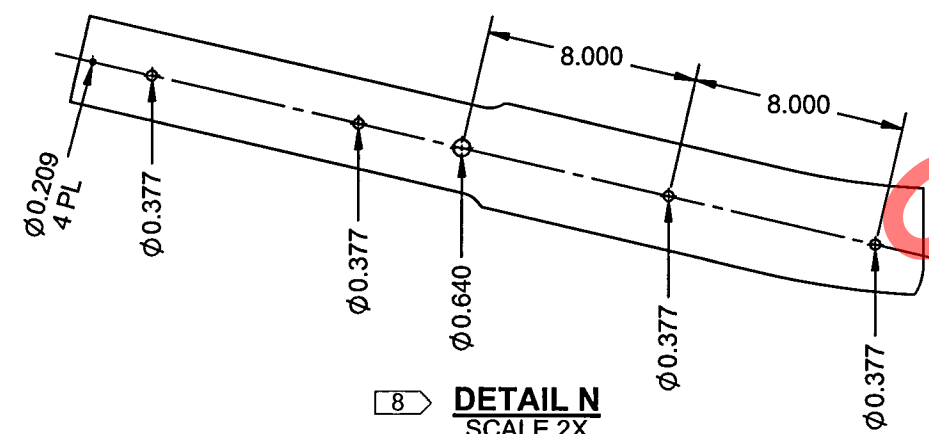
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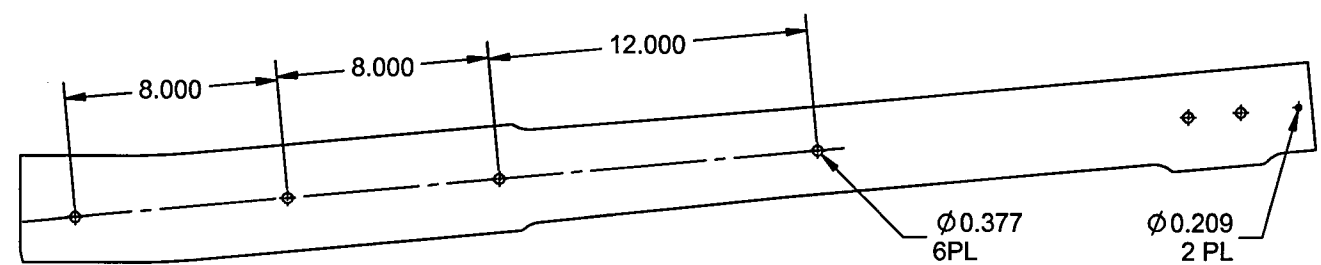
9 D5425-3 FLOAT SKIDTUBE



8 DETAIL M
SCALE 2X



8 DETAIL N
SCALE 2X



8 DETAIL P
SCALE 2X

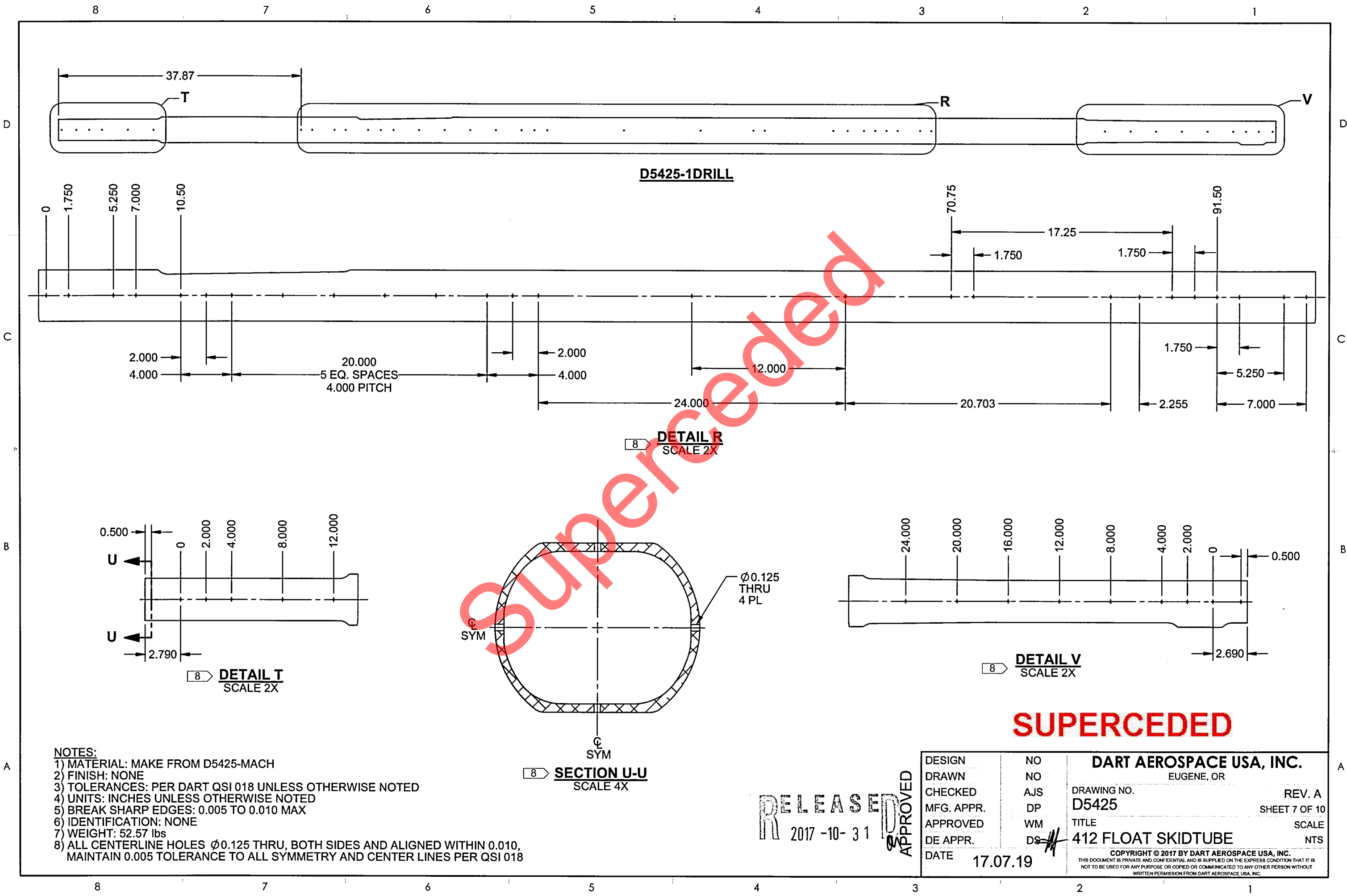
- NOTES:**
- 1) MATERIAL: MAKE FROM D5425-3DRILL
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 52.57 lbs
 - 8) ALL HOLES THRU, BOTH SIDES AND ALIGNED WITHIN 0.010
 - 9) MAXIMUM TWIST ALLOWANCE 3° BETWEEN FWD AND AFT BEND, 3° FROM EXTRUSION CENTERLINE AT ANY POINT
 - 10) MAXIMUM 5% CRUSHING PER QSI 038 7.1

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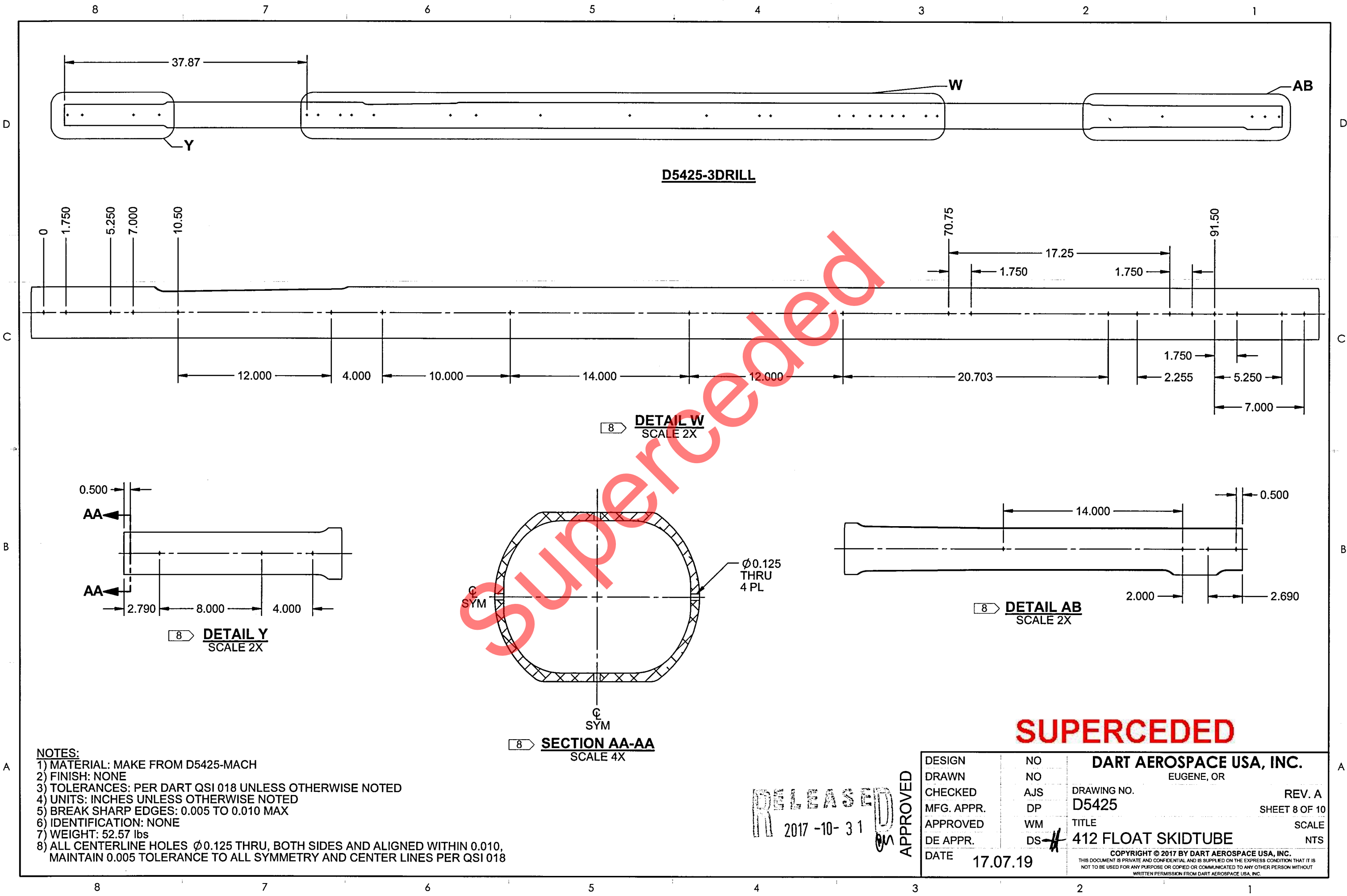
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NOTES:
1) MATERIAL: MAKE FROM D5425-MACH
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 52.57 lbs
8) ALL CENTERLINE HOLES $\varnothing 0.125$ THRU, BOTH SIDES AND ALIGNED WITHIN 0.010, MAINTAIN 0.005 TOLERANCE TO ALL SYMMETRY AND CENTER LINES PER QSI 018

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MFG. APPR.	DP	D5425	SHEET 7 OF 10
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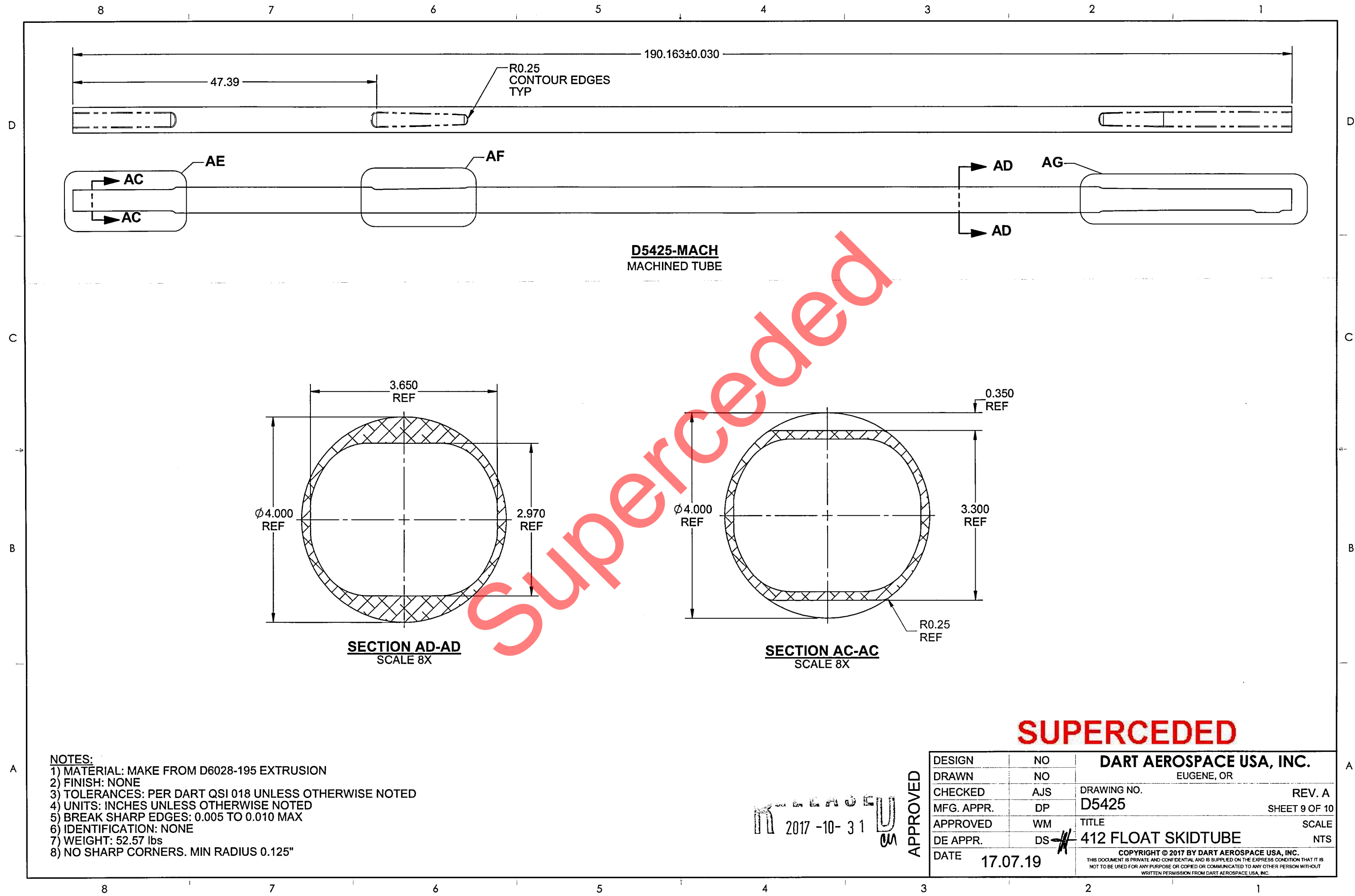


- NOTES:
- 1) MATERIAL: MAKE FROM D5425-MACH
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 52.57 lbs
 - 8) ALL CENTERLINE HOLES Ø 0.125 THRU, BOTH SIDES AND ALIGNED WITHIN 0.010, MAINTAIN 0.005 TOLERANCE TO ALL SYMMETRY AND CENTER LINES PER QSI 018

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2017-10-31

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- NOTES:
- 1) MATERIAL: MAKE FROM D6028-195 EXTRUSION
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 52.57 lbs
 - 8) NO SHARP CORNERS. MIN RADIUS 0.125"

2017-10-31

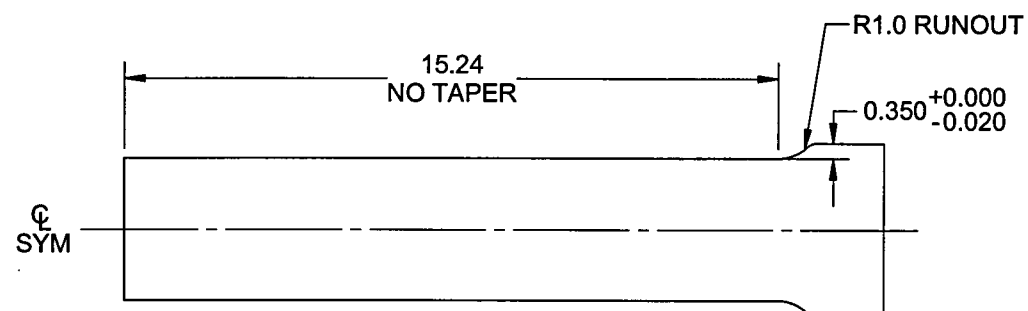
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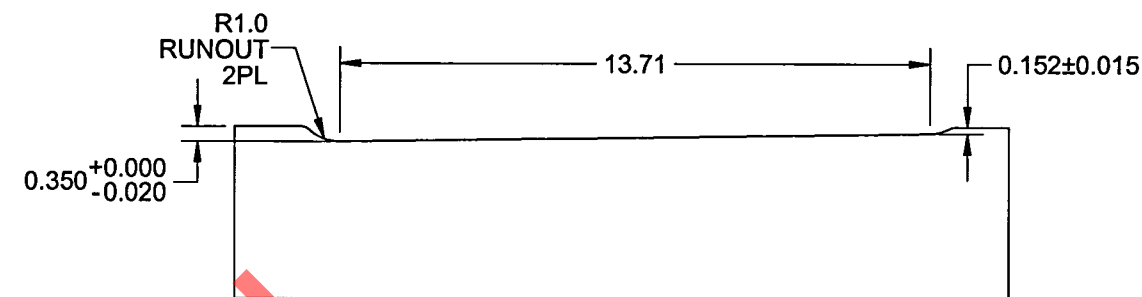
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CHECKED	AJS	DRAWING NO.	REV. A
MFG. APPR.	DP	D5425	SHEET 9 OF 10
APPROVED	WM	TITLE	SCALE
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8 7 6 5 4 3 2 1

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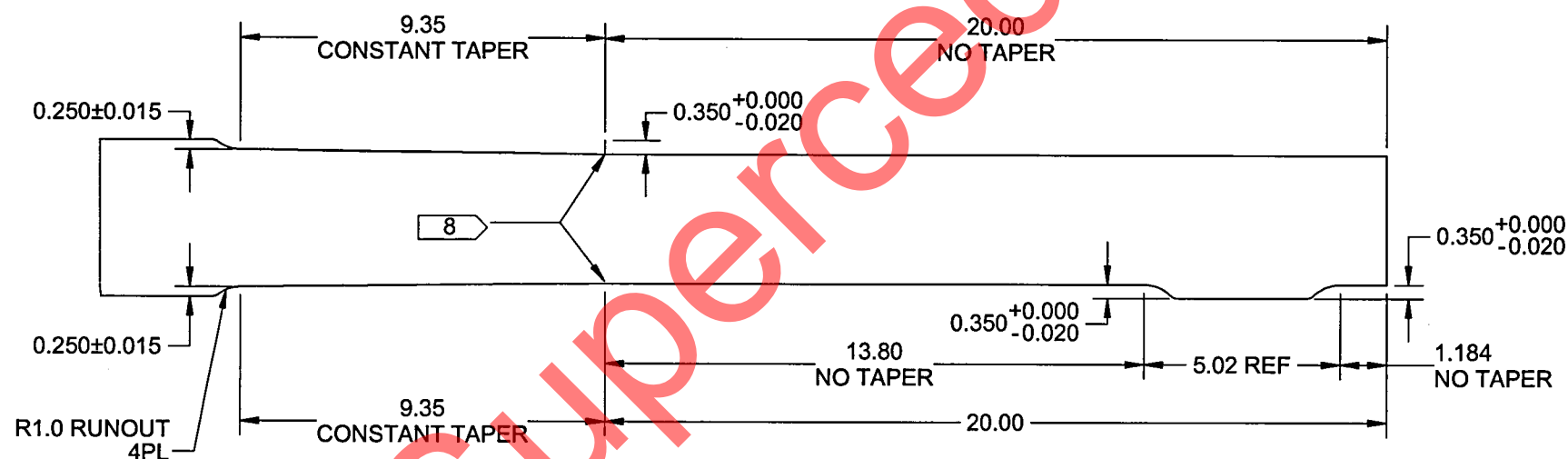


DETAIL AE
SCALE 3X



DETAIL AF
SCALE 3X

C



DETAIL AG
SCALE 3X

B

A

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MFG. APPR.	DP	D5425	SHEET 10 OF 10
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D

C

B

A

8 7 6 5 4 3 2 1